

Date: Tuesday, 3/11/2008 1:17:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : L/H LOW PROFILE BASKET BASE ASSY
 Job Number : 37814
 Estimate Number : 13145
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 37286
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-01-30 DD verified by: EC

Part Number : D3712042 - 042
 Drawing Number : D3712 UNDER REVIEW ASS 08-03-11
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each

POSITIVE
RECALL
08-03-11

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3726-1	M107315
2	D3727-1	M107315
2	D3734-1	M107315
6	D3735-1	M107315
3	D3739-1	M107315
3	D3740-1	M107315

2- deburr

Pl 08-03-15

2.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch 336479

Pl 08-03-15

3.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch 336481

Pl 08-03-15

3.1

D3759-1

QTY 21

Batch: B37663

Pl 08-03-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37626

Plc 08.03.15

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch B37305

Plc 08.03.15

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch: B37611

Plc 08.03.15

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1

2- take D3746-1 and drill holes as per dwg D3646

3- drill holes in both D3727-1 as per dwg D3727

4- take 1x D3735-1 and drill holes as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

Plc 08.03.15
SD 08/03/15

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-15

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch
38sq.ft M304EX0.75-16F Expanded Metal

Batch
M107368

Batch
M107368

PD 08/03/15

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

PD 08-03-15

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-15 (1)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-15 (1)

14.0

POWDER COATING

POWDER COATING



M107005



(18)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M. L. / a.m. 08/03/15

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-03-17 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA.

mf 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 28/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

HD 08/03/17

Job Completion



U 08-03-17

POSITIVE RECALL

EFFECTIVE 08.03.11 AUTH U

RELEASED RT DATE 08.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

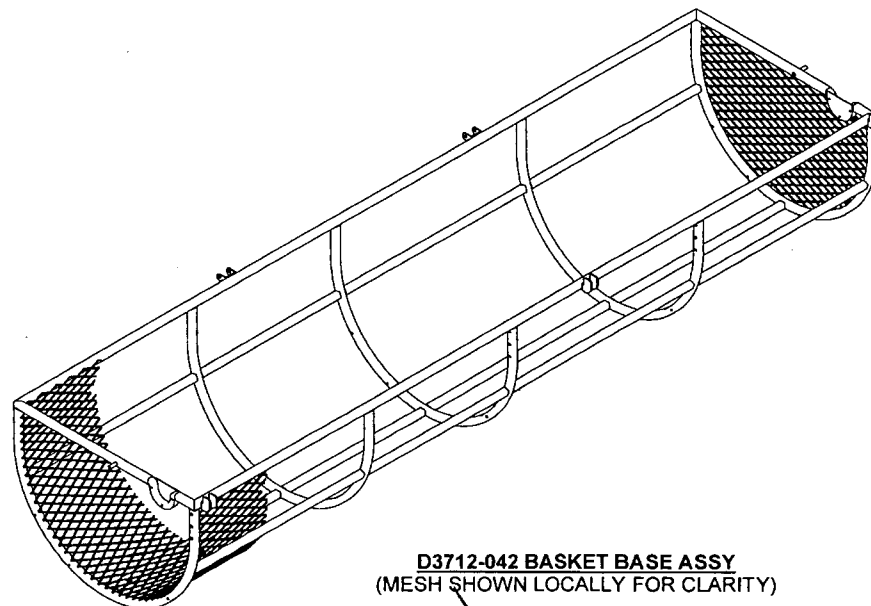
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT



D3712-042 BASKET BASE ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

UNDER REVIEW

SEE EIC/10
TIMM APPR. ADDED
PER SHOP REQUEST

RELEASED
11 CE 08.02.25

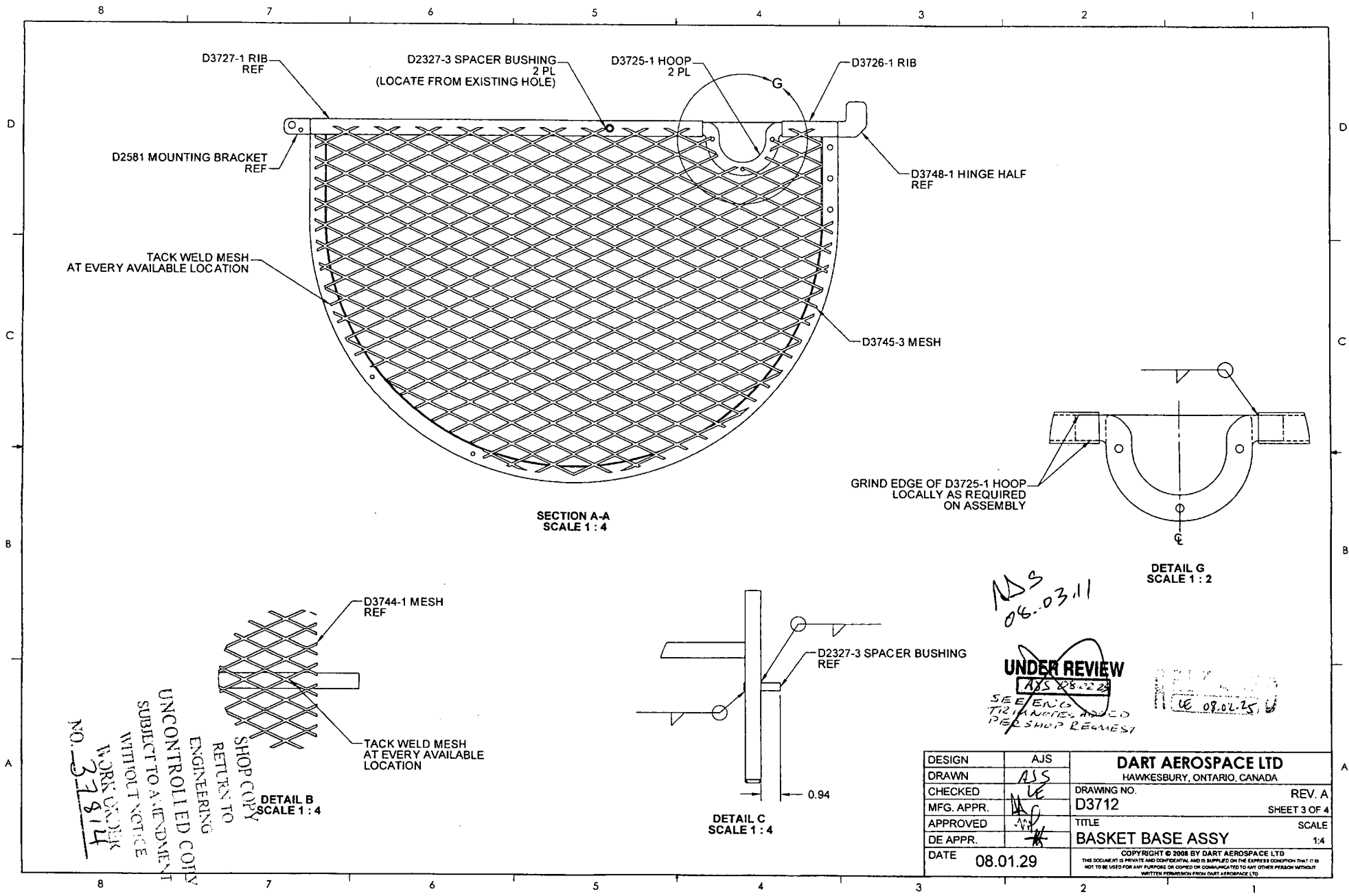
MS
08-03-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37814

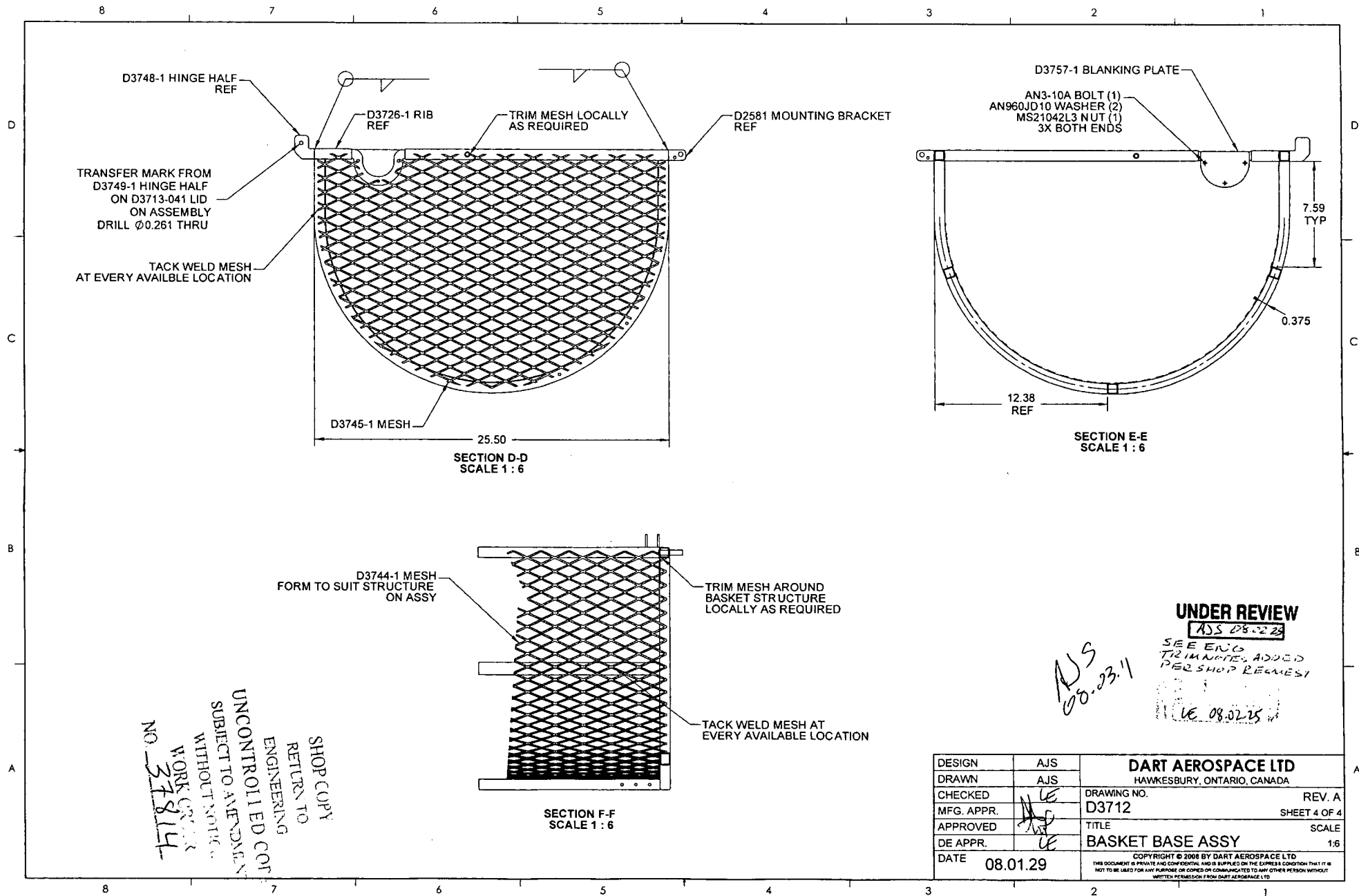
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 41.53 lbs
- 8) WELDING: PER DART QSI 004

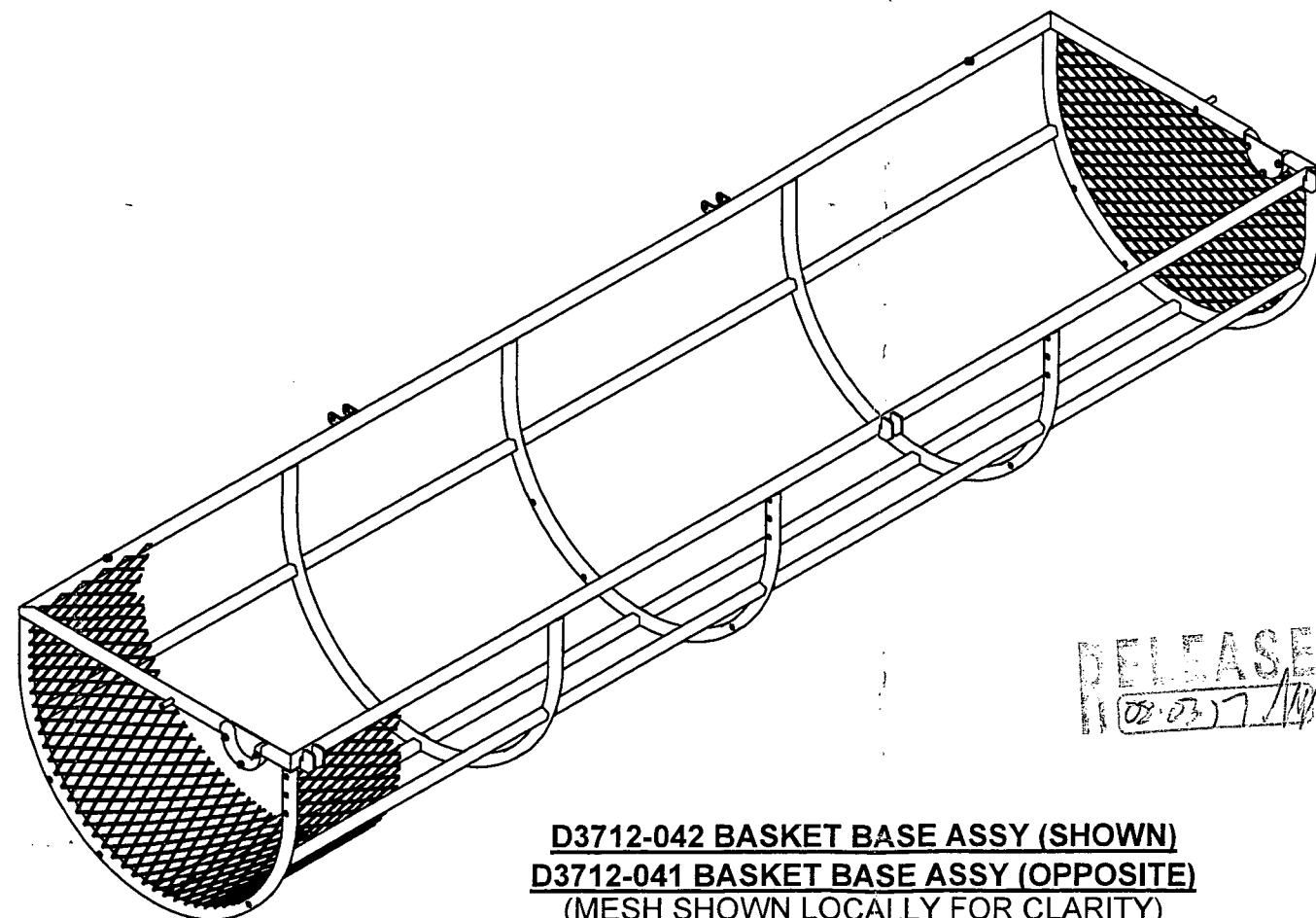
A NEW ISSUE		AJS	08.01.29
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3712 SHEET 1 OF 4 TITLE BASKET BASE ASSY SCALE NTS DATE 08.01.29 <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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APPROVED	KE		
DE APPR.	KE		



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DE APPR.	MA	BASKET BASE ASSY	1:4
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	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
△B	X		D3712-041	BASKET BASE ASSEMBLY
		X	D3712-042	BASKET BASE ASSEMBLY
	2	2	D2327-3 ✓	SPACER BUSHING
	2	2	D2581 ✓	MOUNTING BRACKET
△B	2	2	D2931	BUMPER
	2	2	D3725-1 ✓	HOOP
	2	2	D3726-1 ✓	RIB
	2	2	D3727-1 ✓	RIB
	2	2	D3734-1 ✓	RIB
	5	5	D3735-1 ✓	RIB
	1	1	D3735-3 ✓	RIB
	3	3	D3739-1 ✓	RIB
	3	3	D3740-1 ✓	RIB
	1	1	D3744-1 ✓	MESH
	1	1	D3746-1 ✓	RIB
	1	1	D3746-3 ✓	RIB
	2	2	D3746-5 ✓	RIB
	1	1	D3746-7 ✓	RIB
	3	3	D3748-1 ✓	HINGE HALF
	2	2	D3757-1	BLANKING PLATE
△B	21	21	D3759-1 ✓	BUSHING
△B	6	6	AN3-11A	BOLT
△B	2	2	AN960JD8	WASHER
	12	12	AN960JD10	WASHER
△B	2	2	MS20600AD4W3	RIVET
	6	6	MS21042L3	NUT

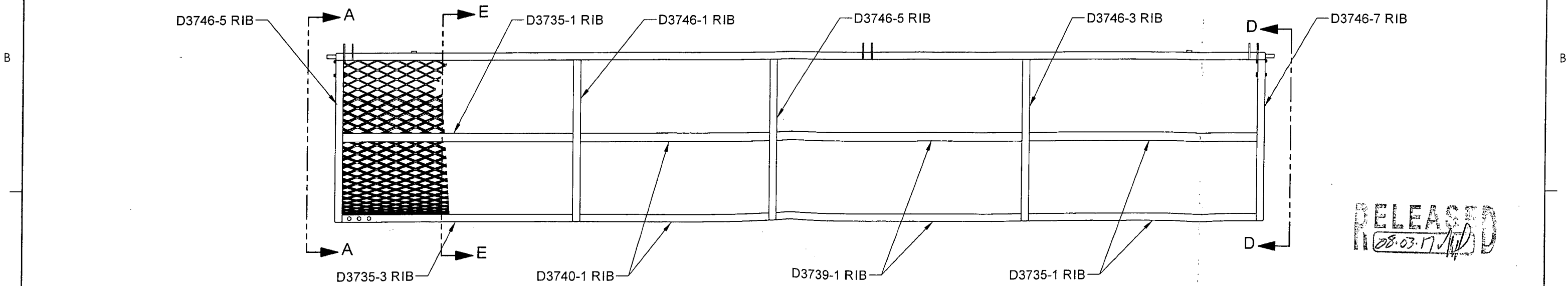
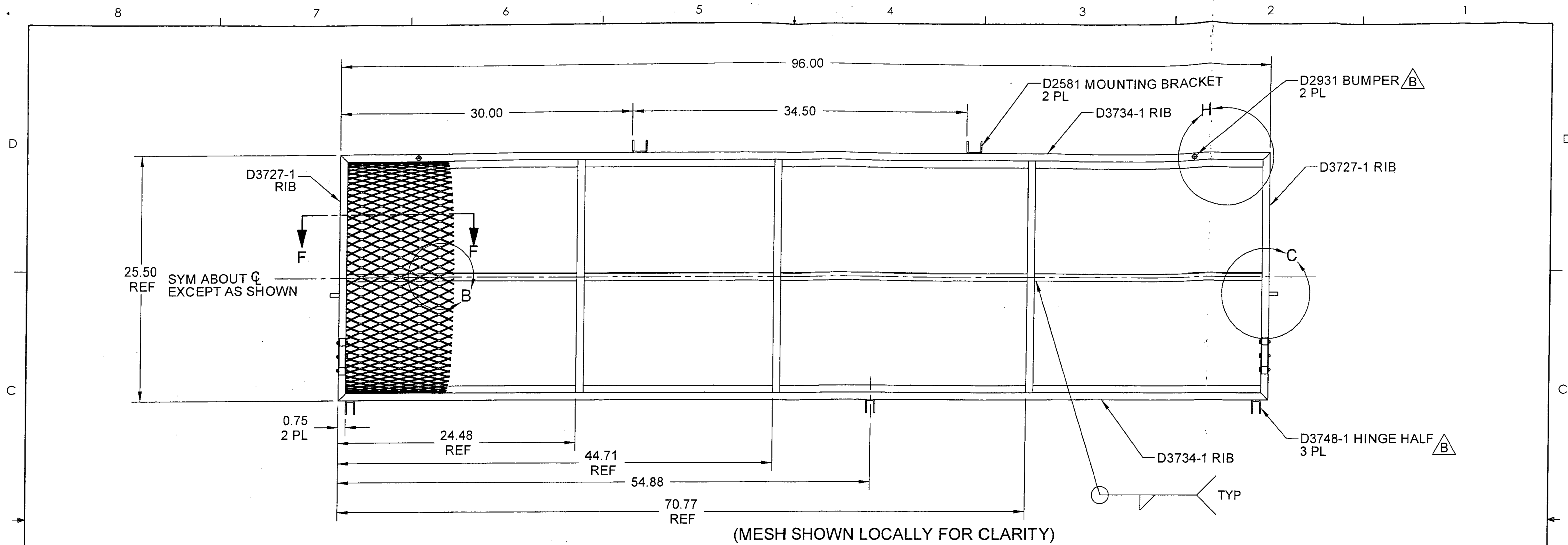


D3712-042 BASKET BASE ASSY (SHOWN)
D3712-041 BASKET BASE ASSY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) MASK ALL HOLES PRIOR TO POWDER COATING.

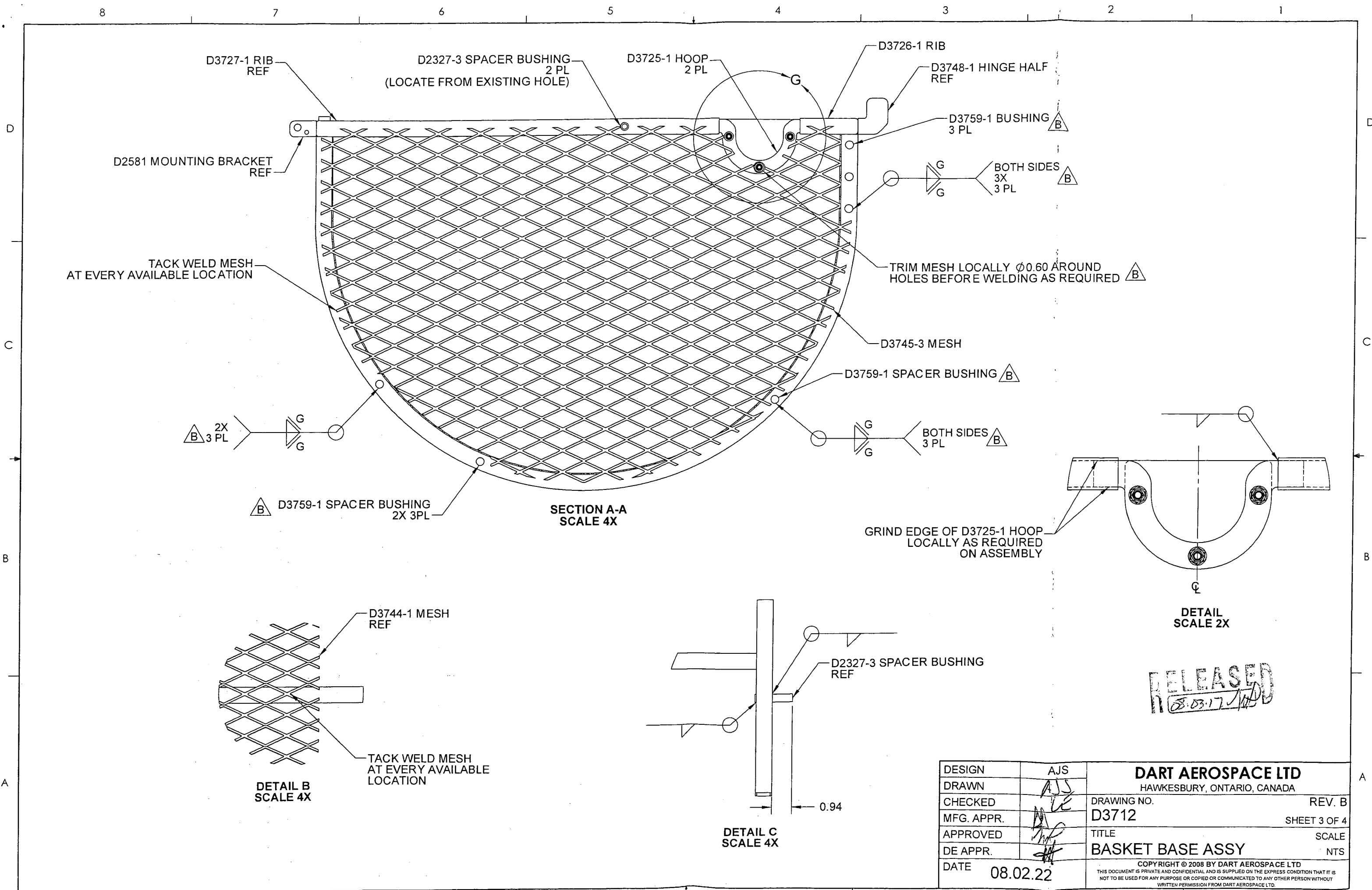
B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4, ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3712	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET BASE ASSY	NTS
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RELEASED
28-03-17

- 9 D3712-041 BASKET BASE ASSY (OPP)
- 9 D3712-042 BASKET BASE ASSY (SHOWN)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
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